

<b>Customer</b>	:	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b>	:	ARM
<b>Job Number</b>	:	32027			
<b>Estimate Number</b>	:	11376			
<b>P.O. Number</b>	:	N/A	<b>Part Number</b>	:	D33872
<b>This Issue</b>	:	4/23/2007      S.O. No. : N/A	<b>Drawing Number</b>	:	D3387- <del>UNDER REVIEW</del>
<b>Prsht Rev.</b>	:	NC	<b>Project Number</b>	:	N/A
<b>First Issue</b>	:	N/A      Type : MACHINED PARTS	<b>Drawing Revision</b>	:	<del>UNDER REVIEW</del> A
<b>Previous Run</b>	:	27289	<b>Material</b>	:	N/A
<b>Written By</b>	:	[Signature]	<b>Due Date</b>	:	5/1/2007
<b>Checked &amp; Approved By</b>	:	[Signature] 07.04.23	<b>Qty:</b>		2 Um: Each
<b>Comment</b>	:	Est:A 05.06.10 New Issue KJJ/JLM Est:B 06.03.22 Split c'sink op. EC			

## Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X06000	6061-T6 Bar .50" x 6.0"
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**Comment:** Qty.: 1.5680 f(s)/Unit    Total : 3.1359 f(s)

6061-T6 Bar .50" x 6.0"

Material: 6061-T6/T651 (QQ-A-200/8)

(M6061T6B0.500x06.000)

Identify for D3387-2

Batch: M101919

B 102508

J.L 07/04/24

2.0	BAND SAW	BAND SAW
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**Comment:** BAND SAW

Cut blank: 6.000" x 0.500" x 17.800" long

JL 07/04/24

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA512 and Dwg D3387

Identify as D3387-2

Tumble and Deburr NO sharp edges

JL 07/04/24

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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**Comment:** CONVENTIONAL MILLING MACHINE

C'sink Ø0.375" as per Dwg D3387

JL 07/04/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: FE Date: 07/04/26  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 4/23/2007 3:42:12 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 32027

Part Number: D33872

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 07/04/24

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

ML 07/04/24

3

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: UA25

PE 07-04:25 3

8.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/26

Job Completion



U 07-04-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 32021
<b>Description:</b> Arm		<b>Part Number:</b> D3387-2
<b>Inspection Dwg:</b> D3387 <b>Rev:</b> A		<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
                         
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.500	+/-0.010	.502	✓			
7.577	+/-0.010	5.580	✓			
R0.030	+/-0.010	.030	✓			
Ø0.191	+0.005/-0.000	.193	✓			
1.700	+/-0.010	1.701	✓			
0.188	+/-0.010	.188	✓			
11.405	+/-0.010	11.406	✓			
Ø0.507	+0.000/-0.001	.507	✓			
2.033	+/-0.005	2.033	✓			
R0.300	+/-0.010	.300	✓			
1.000	+/-0.005	1.000	✓			
2.000	+/-0.010	2.001	✓			
1.347	+/-0.005	1.348	✓			
0.250	+/-0.010	.254	✓			
R0.125	+/-0.010	.125	✓			
0.125	+/-0.010	.130	✓			
R0.032	+/-0.010	.032	✓			
Ø0.375 x100°	+/-0.010	373X100°	✓			
0.500	+/-0.010	.501	✓			
0.300	+/-0.010	.298	✓			

<b>Measured by:</b> JL	<b>Audited by:</b> JML	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 07/04/24	<b>Date:</b> 07/04/24	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.27	New Issue	KJ/JLM	<i>[Signature]</i>

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

**HAWKESBURY, ONTARIO, CANADA**

REV. A

**SHEET 1 OF 1**

## SCALE

DESIGN	DRAWN BY		DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A	
DATE			SHEET 1 OF 1	
05.01.18		ARM	SCALE 1:3	

**REVIEW**

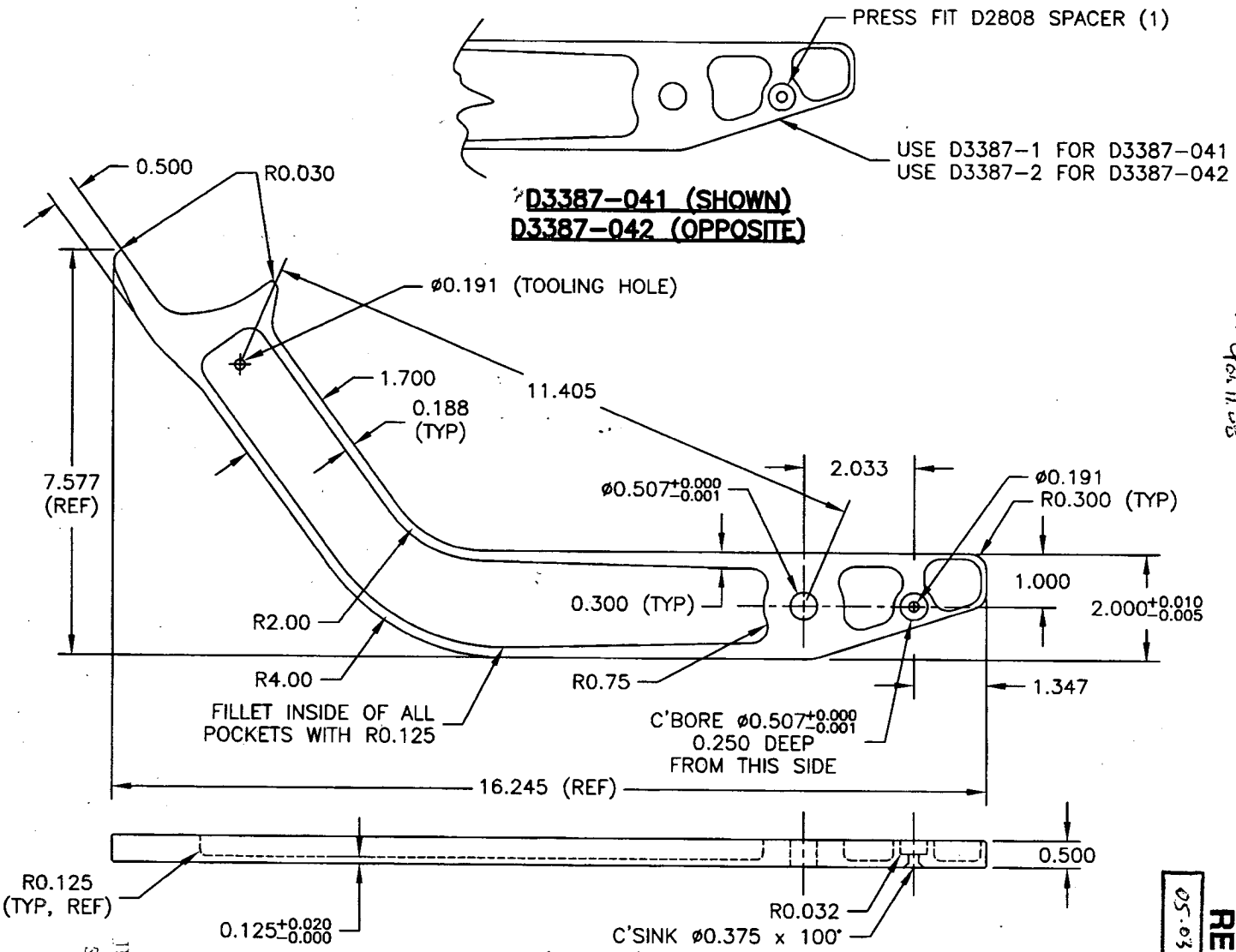
~~0000114~~

Arm height to change

OK for 11.02

**RELEASED**

05.03.1



D3387-1 (SHOWN)  
D3387-2 (OPPOSITE)

## GENERAL NOTES

2) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11) 0.500 THICK  
(REF DART SPEC. M6061T6B0.500)

- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES  
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
5) ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE  
WORK ORDER  
NO. 32027

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